

Amendment to the Claims:

This listing of claims will replace all prior versions of claims in the application:

Claims 1 – 25. (Canceled)

26. (New) A roll without a winding tube comprising one sheet of non-moist flexible material formed by rolling the sheet around a winding axis, with a center unwinding first strip forming a projection along said axis in relation to at least one part of at least one side of the roll.

27. (New) A roll according to claim 26, wherein the flexible material is an absorbent fibrous material.

28. (New) A roll according to claim 26, wherein the first strip has a length between 0.3 and 20 cm.

29. (New) A roll according to claim 26, wherein the first strip comprises a portion of an internal end of the sheet.

30. (New) A roll according to claim 29, wherein the first strip is formed by crosswise folding on the winding axis of said portion of said internal end.

31. (New) A roll according to claim 30, wherein the first strip is tapered.

32. (New) A roll according to claim 26, wherein the first strip comprises an end portion of the sheet projecting outward in relation to a groove or a recess made on a side of the roll adjacent the winding axis.

33. (New) A roll according to claim 26, wherein the first strip is visually reinforced by coloring.

34. (New) A roll according to claim 26, wherein the first strip is mechanically reinforced by a supplementary element.
35. (New) A roll according to claim 26, wherein the first strip comprises an element joined onto a portion of an internal end of the sheet.
36. (New) A manufacturing process of a roll according to claim 26, 27 or 28, said process comprising crosswise folding of the first strip at a portion of the end of the sheet, in such a way that the portion forms a non-right angle in relation to the winding axis of the roll and extends over an edge of the sheet before the sheet is made into a roll.
37. (New) A process according to claim 36, further comprising making the sheet into a roll on a winding support.
38. (New) A process according to claim 36, wherein first turns at a center of the roll are not connected to one another.
39. (New) A process according to claim 37, further comprising:
- (a) rolling of the sheet around the winding support,
 - (b) arranging the sheet in such a way that the sheet extends out to an end perpendicular on each side of winding support,
 - (c) folding the end of the sheet onto the winding axis of the roll,
 - (d) maintaining a portion of the end of the sheet on the winding support, and
 - (e) placing the winding support in rotation to roll the sheet, wherein prior to the placing in rotation of the winding support, arranging said portion of the end of the sheet so that the portion extends outside a side edge of the sheet.
40. (New) A process according to claim 39, further comprising placing the winding support in relation to the sheet so that the portion of the end of the sheet is arranged on a side of the

winding support, said portion of the end being returned onto the winding support with a crosswise movement.

41. (New) A process according to claim 40, wherein said crosswise movement is provided by a stream of air.

42. (New) A process according to claim 40, wherein said crosswise movement is effected by friction of a part of the portion of the end.

43. (New) A process of making a roll according to claim 26, 27 or 28, said process comprising:

- (a) cutting the sheet of said flexible material into a plurality of individual sheets arranged side by side,
- (b) moving a portion of an end of the first strip of said individual sheets crosswise,
- (c) rolling each end of said sheets around a winding support to provide a plurality of rolls, and
- (d) separating each of the rolls after formation of said rolls to thereby release the first strip.

44. (New) A manufacturing process for a roll according to claim 26, 27 or 28, said process comprising:

- (a) forming the roll by rolling the sheet onto a winding support,
- (b) extracting the winding support, and
- (c) causing an end portion of the first strip of the sheet to glide outside an opening made by the winding support before the opening caves in on itself in order to form said first strip.

45. (New) A process according to claim 44, wherein the sheet of flexible material is first cut into a plurality of individual sheets arranged side by side,

- (a) said sheets are rolled around the winding support,
- (b) each of the rolls formed from the individual sheets is separated after formation, and

(c) end portions of the sheets are made to slide outside the opening created by the winding support.

46. (New) A process according to claim 44, wherein the sheet of flexible material is rolled around the winding support to form a "log" along a total width of the sheet, sawing the "log" to form a plurality of rolls, and sliding end portions of the rolls outside the opening made by the winding support.

47. (New) A process for manufacturing a roll according to claim 26, 27 or 28, said process comprising:

- (a) cutting the flexible material into a plurality of individual sheets arranged side by side by a cutting device,
- (b) winding a first turn or first turns of the roll,
- (c) moving an end portion of the first strip crosswise of the cutting device,
- (d) rolling said sheets around a winding support to provide a plurality of rolls, and
- (e) separating each of the rolls after formation, the first strip thus being made by the end portion of each of said sheets and extending outward from center onto one side of the roll.

48. (New) A process for manufacturing a roll according to claim 26, 27 or 28, said process comprising cutting the sheet of flexible material into a plurality of individual sheets arranged side by side, moving the first strip of each of the sheets crosswise of a winding support, the first strip of each coming from ends of the sheets which project outward on one side of the rolls after separating said rolls from the winding support.

49. (New) A process for manufacturing a roll according to claim 32, comprising:

- (a) cutting the sheet of flexible material by a first cutting device into individual sheets arranged side by side, and

(b) providing the groove by crosswise movement of a second cutting device initially aligned with the first cutting device, on a specific length of the sheet, and upon return of the second cutting device to an initial position, eliminating a part of the sheet.

50. (New) A process for manufacturing a roll according to claim 49, wherein the groove is made after formation of the roll.

51. (New) A process for manufacturing a roll according to claim 35 further comprising adding to the end of the sheet a supplemental element prior to winding or after separation of the roll.